

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011825**Date Inspected:** 02-Feb-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr.Liu Fa wen /Chen xi**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder(OBG)**Summary of Items Observed:**

This CALTRANS OSM Quality Assurance Inspector (QA) Surendra Prabhu was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

BAY-1 -TRAVELER RAIL (TR)

This QA Inspector observed the following work in progress:

Flux Cored Arc Welding (FCAW) welding of weld joint 21TR4-002-003. Welder is identified as 215397. ZPMC Quality Control (QC) is identified as Mr. Tian Lei. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2231-TC-U5-F.

Flux Cored Arc Welding (FCAW) welding of weld joint 21TR1-001-001. Welder is identified as 219188. ZPMC Quality Control (QC) is identified as Mr. Tian Lei. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2231-TC-U5-F.

Flux Cored Arc Welding (FCAW) welding of weld joint 21TR4-001-003. Welder is identified as 219188. ZPMC Quality Control (QC) is identified as Mr. Tian Lei. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2231-TC-U5-F.

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BAY-3-TRAVELER RAIL (TR)

Flux Cored Arc Welding (FCAW) welding of weld joint 20TR2-015-015. Welder is identified as 214945. ZPMC Quality Control (QC) is identified as Mr. Guo Yuan Ting. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2231-TC-U5-F.

Flux Cored Arc Welding (FCAW) welding of weld joint 20TR2-015-015. Welder is identified as 214945. ZPMC Quality Control (QC) is identified as Mr. Guo Yuan Ting. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2231-TC-U5-F.

Flux Cored Arc Welding (FCAW) welding of weld joint 20TR2-012-011. Welder is identified as 044824. ZPMC Quality Control (QC) is identified as Mr. Guo Yuan Ting. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2231-TC-U5-F.

BAY-5-TRAVELER RAIL (TR)

This QA Inspector observed ZPMC welding personnel performing Buttering by Flux Cored Arc Welding (FCAW) process for 10TR1-006. Welder is identified as 204342. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e. WPS-345-FCAW-1G (1F)-Repair-1. The Buttering welding was been performed against the B-CWR1102 and ZPMC Quality Control (QC) is identified as Mr. Zhong Chong biao and Certified Welding Inspector (CWI) is identified as Mr. Liu Fa wen.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and Quality Control (QC) concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Prabhu, Surendra	Quality Assurance Inspector
Reviewed By:	Miller, Mark	QA Reviewer
